

Work Order ID 74523

Monday, October 03, 2011 4:03:01 PM



Page 1

Item ID: D2844-1

Accept



Setup Start



Revision ID:

Item Name: Arm

Stop



Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 11/10/04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2844

Rev A

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Form per Dwg D2844 using brake and bending Jig DT 8238-B ☐ Debur

SB 11/01/04

40 E/S 11/10/05

10

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8 u/10/06

110

120

0.00



White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

Powdercoat

Memo

0.00

Powder Coating

START TIME:

☐ FINISH TIME:

☐ OVEN TEMPERATURE:

1:15

1:45

10X Ø m/ 11/10/12

32005

M 118439

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74523



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Item ID: D2844-1	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Arm				
Start Date: 9/30/2011	Start Qty: 10.00		Cust Item ID:	
Required Date: 10/14/2011	Req'd Qty: 10.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				10	BR	11-10-12	
140 	QC6- Inspect dimensions to drawing	0.00							
QC Quality Control	Memo ensure parts are still as per dwg D2844	0.00				M	11	10	13 (10)
150 	Identify as per dwg & Stock Location	0.00							
Packaging Packaging	Memo	0.00				Sg- 10x		11-10-13	

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Work Order ID 74523

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Item ID: D2844-1

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Setup Start



Revision ID:

Stop



Item Name: Arm

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/13
mf
11-10-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, October 03, 2011 4:03:06 PM

Page 1

Work Order ID: 74523

Parent Item: D2844-1

Parent Item Name: Arm



Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B00.11.01 Removed P/O for Powder Coat - in house process EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	214.6323	1.8991	19.99053			
304 RD Tube .500 x .035W													



SB 11/10/05

Location

Loc Qty

Loc Code

MAT017

214.6322723

115535

2.33

116720

1.66068

117598

34.6415923

118702

176

20

W/O:		WORK ORDER CHANGES					
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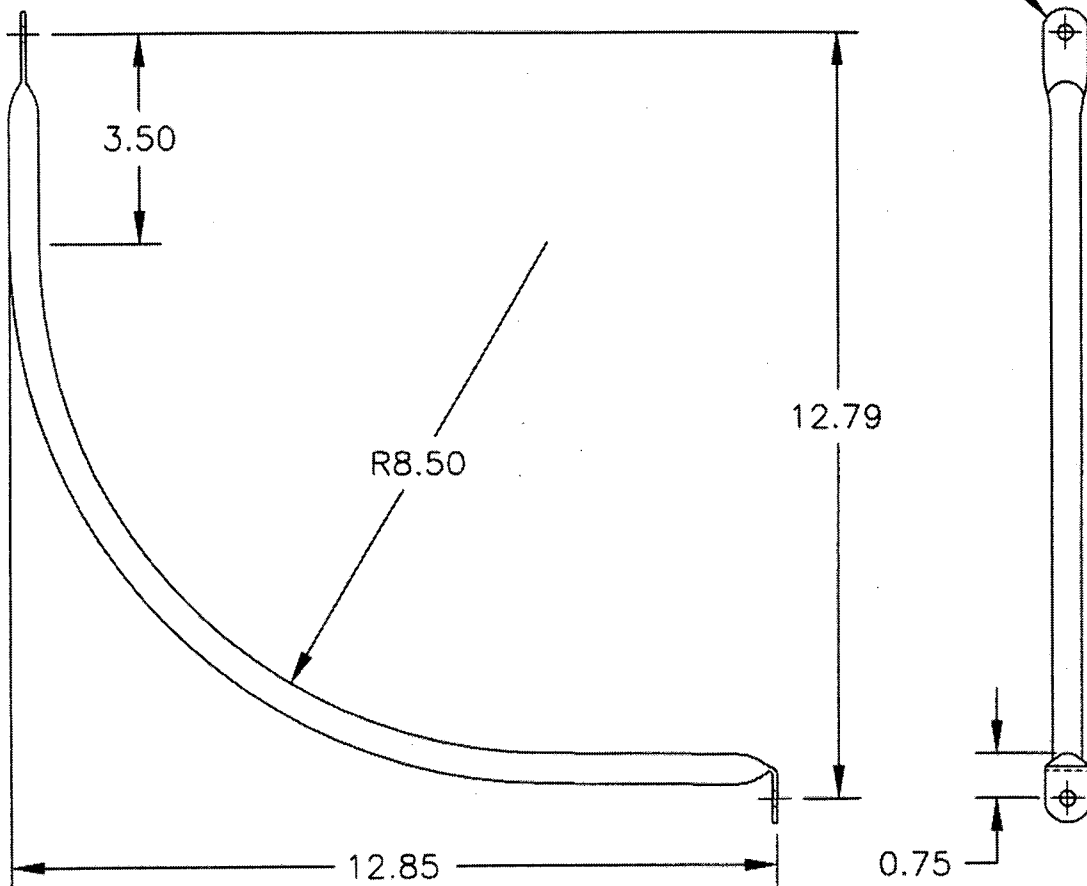
DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DAH</i>	APPROVED <i>CS</i>	DRAWING NO. D2844	REV. A SHEET 1 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3
A	98.10.14	NEW ISSUE	

RELEASED
98.11.11 KE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 74523
M.L.J
11/10/04

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-1

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50$ x 0.035 WALL
ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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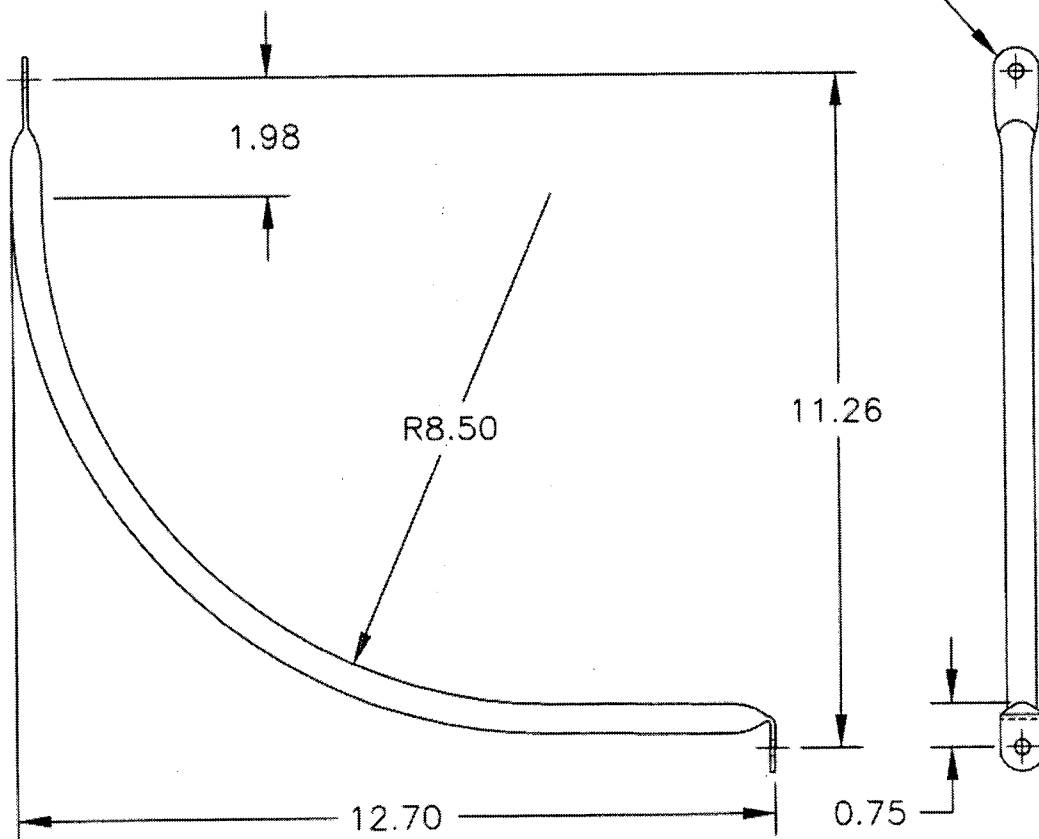
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DAH</i>	APPROVED <i>KE</i>	DRAWING NO. D2844	REV. A SHEET 2 OF 2
DATE 98.10.14	TITLE ARM		SCALE 1:3

RELEASED
98.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



MATERIAL: AISI 304/316 SS TUBE, $\emptyset 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS
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74523

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